



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4883-3**Job Sheet 200415****Part No:** D4883-3**Job Qty:** 6 pcs**Part Name:** End Fitting**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/11/19**Job Tracking No:****Due Date:** 10/2/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C SHEET 2 IPP REV A RQ VERIFIED BY DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	6 pcs	10/2/19	10/2/19	1.00	5.56	Doosan - 1	14/09/23
110	QC 2	6 pcs	10/2/19	10/2/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	19/09/23

Plex 9/11/19 10:10 AM Dart.lajeunesse.marie

DAS
65
9-89**DAS**
65
9-89

					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
					QC 2 - 5		
120	HAAS 4 Axis - B4B <i>HAAS 5 axis</i>	DAS 4 9-89	6 pcs	10/2/19	1.00 4.84	HAAS - 1 - B4B	
						HAAS - 2 - B4B	
						HAAS - 3 - B4B	<i>19-12-01</i>
						HAAS - 4 - B4B	
						130	QC 2
QC 2 - 12							
QC 2 - 14							
QC 2 - 17							
QC 2 - 19							
QC 2 - 2							
QC 2 - 20	<i>19-12-01</i>						
QC 2 - 22							
QC 2 - 23							
QC 2 - 25							
QC 2 - 32							
QC 2 - 33							
QC 2 - 35							
QC 2 - 39							
QC 2 - 4							
QC 2 - 40							
QC 2 - 44							
QC 2 - 45							
QC 2 - 48							
QC 2 - 49							
QC 2 - 50							
QC 2 - 51							
QC 2 - 52							
QC 2 - 57							
QC 2 - 62							
QC 2 - 63							
QC 2 - 8							
QC 2 - 66							
QC 2 - 64							
QC 2 - 65							
QC 2 - 5							
QC 2 - 71							
QC 2 - 73							
QC 2 - 69							
140	QC 8		6 pcs	10/2/19	0.00 0.00	QC 8 - 12	
						QC 8 - 14	<i>19/12/03</i>
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						Plex 9/11/19 10:10 AM Dart.lajeunesse.marie	

				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
150	Outsource - 2 - NDT per QSI038	6 pcs	10/2/19	SKY002-VC	5
160	Packaging 2-1 - Receive - B4B	6 pcs	10/2/19	0.00 0.00	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190	QC 5	6 pcs	10/2/19	0.00 0.00	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

2019-12-09

DEC 09 2019

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DEC 10 2019 40 9-89
					QC 5 - 61	
					QC 5 - 81	
200 Packaging 3-1 - Stock - B4B	6 pcs	10/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	ok
					Packaging 3 - 3 - B4B	✓ ST123
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	ok
210 QC 21 - SA	6 pcs	10/2/19	0.00 0.00		QC 21 - SA - 21	✓ DAS ST123
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - 1- Turn as per Dwg. D4883-3 Turning Detail & Folio FB253. 2- USE DT10004 For sizing blanks.

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - 1-Machine as per Folio Fb253 & Dwg D4883-3 END FITTING. deburr and Break all sharp edges.

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - ssue P/O: _____ Certificate of conformaty is required. LPI AS PER ASTM E1417 LEVEL 2

160 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of conformity is req'd.

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-003	Round Billet, 17-4	6 pcs (1 ea)	100-Doosan - 1	S204931

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-003	6	21	0
Part Specifications				
Specifications could not be found.				

Plex 9/11/19 10:10 AM Dart.lajeunesse.marie

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.10.23	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S216363



Part: D4883-3

Job No: 200415

Serial No/Batch: S216363

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/23/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045329**



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045329

PO Date: 12/5/19

Due Date: 12/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199966	D130-1048-042	D130-1048-042/IIN-D130-1048 B/C	H130/EC130 - Replacement Skidtube - Standard - RH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	12/9/19	1 pcs	0 pcs	1 pcs	\$119.70/pcs	\$119.70
	196768				Firmed	-	12/9/19	1 pcs	0 pcs	1 pcs	\$119.70/pcs	\$119.70
Sub Total:								2	0	2		\$239.40
2	196764	D130-1048-041	D130-1048-041/ IIN-D130-1048 B/C	H130/EC130 - Replacement Skidtube - Standard - LH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	12/9/19	1 pcs	0 pcs	1 pcs	\$119.70/pcs	\$119.70
3	201931	D4464-043	D4464 J	Fuel Tank Assembly : Various STC's ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	12/9/19	1 pcs	0 pcs	1 pcs	\$394.70/pcs	\$394.70
4	200867	D4883-3	D4883	End Fitting : Various STC's ssue P/O: _____ Certificate of conformaty is required. LPI AS PER ASTM E1417 LEVEL 2	Firmed	-	12/9/19	3 pcs	0 pcs	3 pcs	\$79.0333/pcs	\$237.10
	200415				Firmed	-	12/9/19	3 pcs	0 pcs	3 pcs	\$79.0333/pcs	\$237.10
Sub Total:								4	0	6		\$474.20
Grand Total:											\$1,228.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045329



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/9/19 4:14 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO42812	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB045329
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

DAS
40
9-89

6 END FITTINGS , P/N: D4883-3 , J/S: 200415 , 200867

1 FUEL TANK ASSY , P/N: D4464-043 , J/S: 201931

2 RH SKIDTUBES , P/N: D130-1048-042 , J/S: 196768 , 199966

1 LH SKIDTUBE , P/N: D130-1048-041 , J/S: 196764

RECEIVED**DEC 09 2019**

Action Taken:		DART AEROSPACE LTD		Date:	Initial/Stamp:	
LPI C/O IAW ASTM E-1417M-16						
NO CRACK OR LEAK FOUND						
PEN. ZL-67, MPO25403, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						
Miscellaneous AD Review Performed: ☐ No applicable AD's noted ☐ Refer to action taken for applicable AD's						
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN	DOT-APP 20 53-89	DEC 09 2019